

Date: Monday, 2/5/2007 4:03:08 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : FLOOR PROTCOR AFT RH
Job Number : 30661	
Estimate Number : 11235	
P.O. Number : N/A	Part Number : D32814
This Issue : 2/5/2007 S.O. No. : N/A	Drawing Number : D3281 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 2/5/2007 Type : PURCHASED PARTS	Drawing Revision : B
Previous Run : 29644	Material : N/A
Written By : _____	Due Date : 2/28/2007 Qty: 20 Um: Each
Checked & Approved By : <u>07.02.06</u>	
Comment : Est Rev:A 04.07.01 New issue KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	PG	PURCHASING
-----	----	------------



Comment: PURCHASING

Issue P/O: 3051

Description: Floor Protector Aft, RH

Possible Supplier: Delastek

Certificate of Conformity is required

C 207102106 (20)

2.0	D32814P	Floor Protector, Aft RH
-----	---------	-------------------------



Comment: Qty.: 1.0000 Each(s)/Unit Total : 20.0000 Each(s)
 Floor Protector Aft, RH

3.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Receive & Inspect For Transit Damage

Ensure certificate of conformity is attached

7/3/05 (20)

4.0	QC6	DIMENSIONAL CHECK
-----	-----	-------------------



Comment: DIMENSIONAL CHECK

Inspect dimensions as per Dwg D3280 and certification attached. Visual inspection check for void spots and pins.

2070305 (20)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
-----	-------------	-----------------------



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: _____

04/03/07 (20)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: ☒ Date: 07/03/08

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Monday, 2/5/2007 4:03:08 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: FLOOR PROTECTOR AFT RH

Job Number: 30661

Part Number: D32814

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(20)

Comment: FINAL INSPECTION/W/O RELEASE

07/03/08

Job Completion



U 07/03.08

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

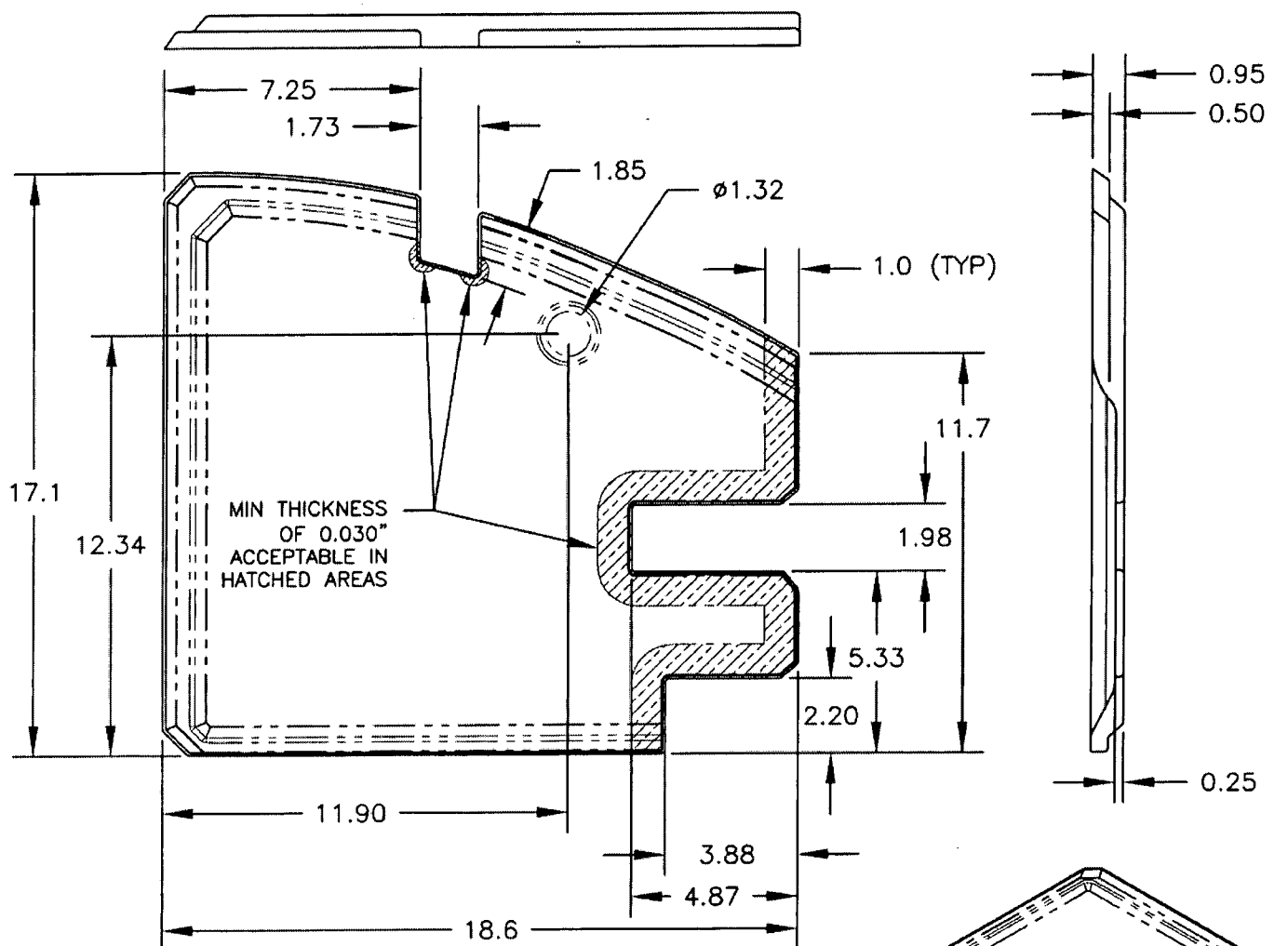
QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

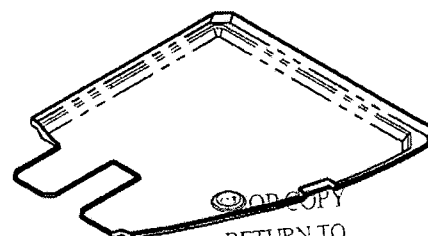
NOTE: Date & initial all entries



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>HH</i>	APPROVED <i>HH</i>	DRAWING NO. D3281	REV. B SHEET 1 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5
A	04.05.03	NEW ISSUE	
B	05.11.25	NOW LEXAN; DIMS AS MANUFACTURED	



RELEASED
05.12.01



D3281-1 FLOOR PROTECTOR, FWD LH

- 1) THERMOFORM D3281-1 USING MOLD D3281-1T1, TRIM USING D3281-1T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

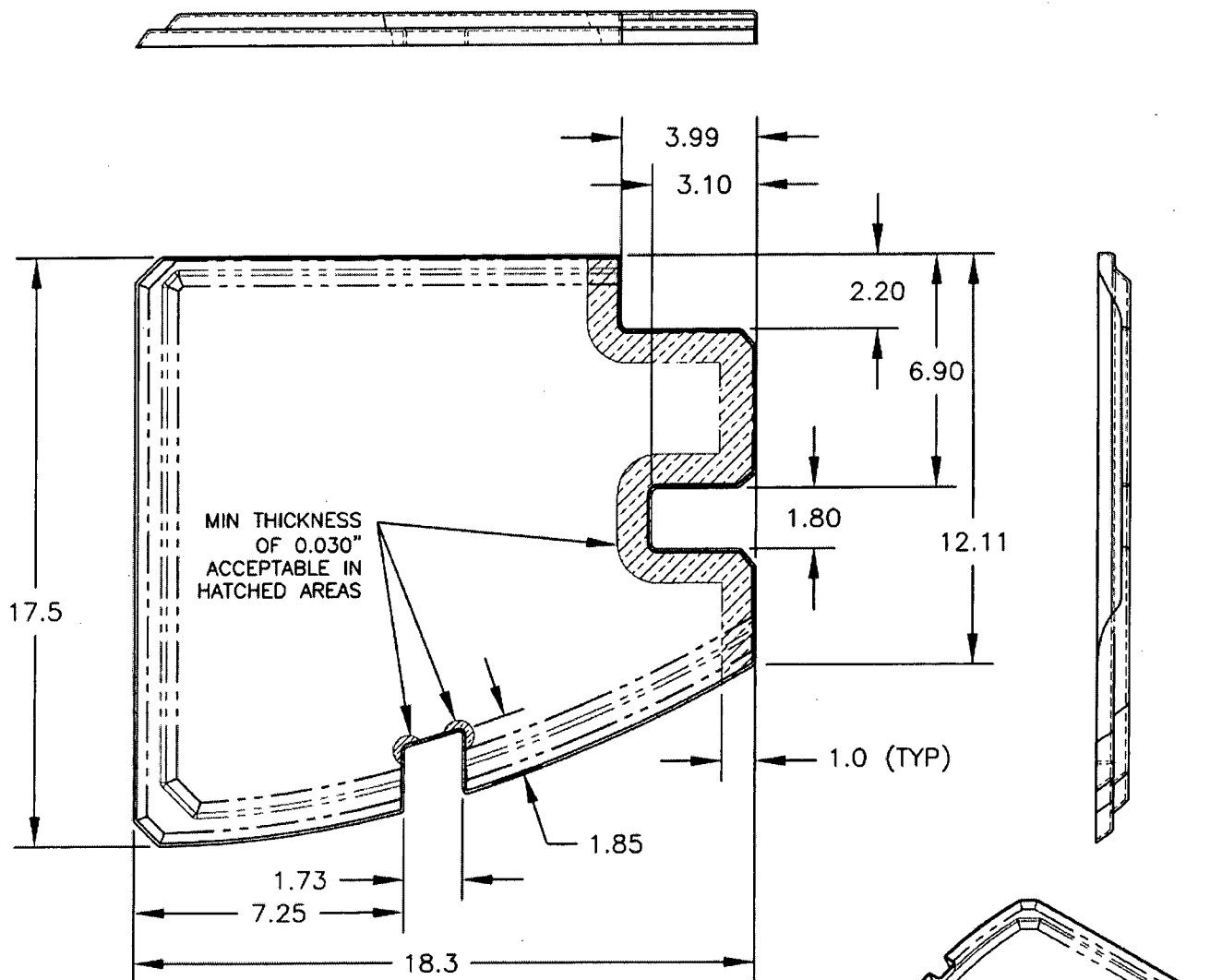
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30661

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3281	REV. B SHEET 2 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5



RELEASED
05.12.01

D3281-2 FLOOR PROTECTOR. FWD RH

- 1) THERMOFORM D3281-2 USING MOLD D3281-2T1, TRIM USING D3281-2T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

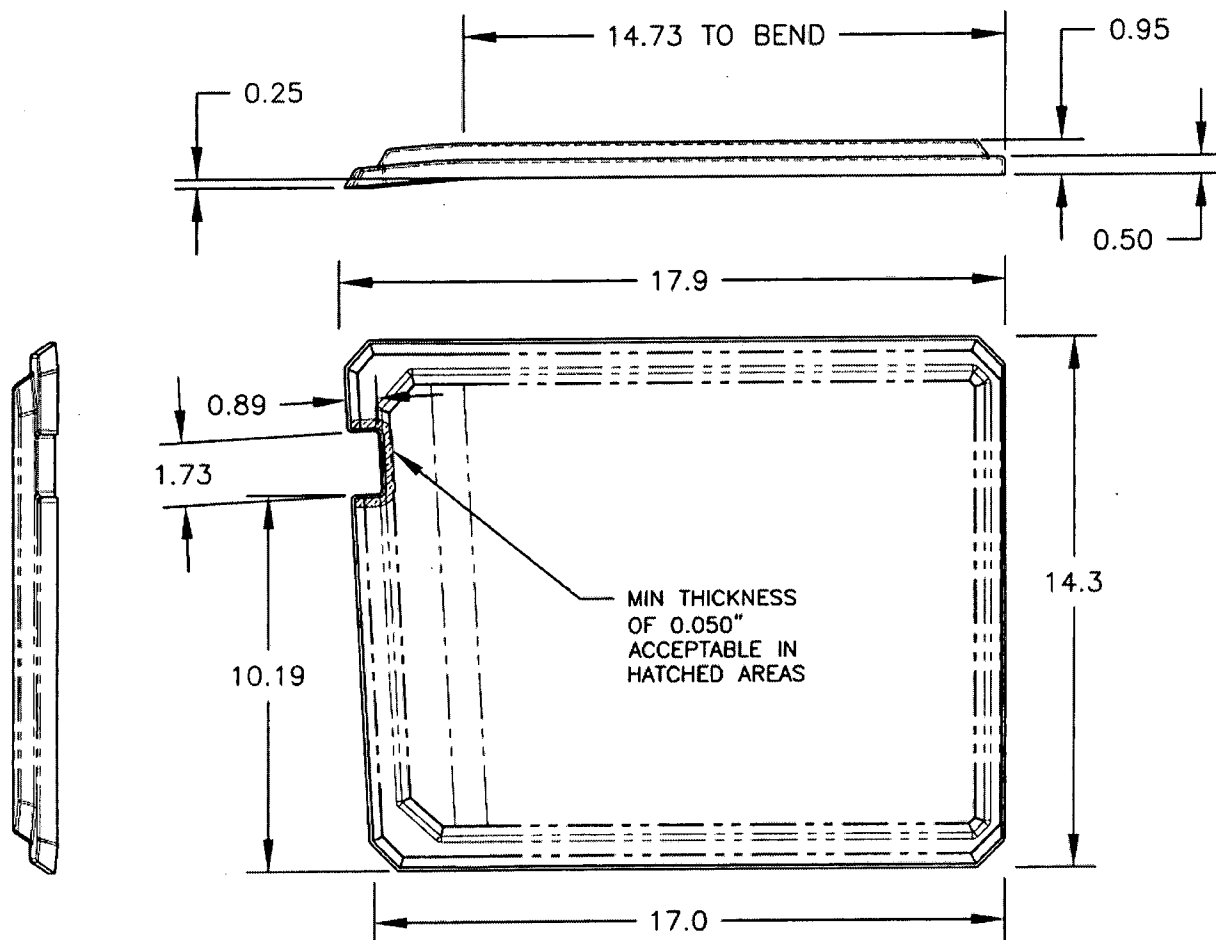
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30661

Copyright © 2004 by DART AEROSPACE LTD

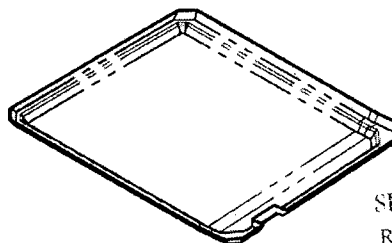
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DESIGN <i>CP</i>	DRAWN BY <i>CP</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3281	REV. B SHEET 3 OF 3
DATE 05.11.25		TITLE FLOOR PROTECTOR	SCALE 1:5



RELEASED
05.12.01. *[Signature]*



SHOP COPY
RETURN TO
ENGINEERING

D3281-3 FLOOR PROTECTOR, AFT LH (SHOWN)
D3281-4 FLOOR PROTECTOR, AFT RH (OPPOSITE)

- 1) THERMOFORM D3281-3 USING MOLD D3281-3T1, TRIM USING D3281-3T2
THERMOFORM D3281-4 USING MOLD D3281-4T1, TRIM USING D3281-4T2
- 2) MATERIAL: LEXAN F6006 BLACK No.700, 0.125 THICK
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) MIN. THICKNESS AFTER FORMING IS 0.080" EXCEPT AS SHOWN

UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 30661

Copyright © 2004 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.



DELASTEK COMPOSITES INC.
2699, 5ième Avenue
Local 14, PORTE -A-
Grand-Mère, Québec G9T 5K7
Can **Fax (819) 533-3494 **

PACKING SLIP CERTIFICATE OF COMPLIANCE

Invoice #	11643
Customer #	DART

Telephone: (819) 533-5788

Warehouse: MAIN

Bill to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Ship to:

Dart Aerospace Ltd.
1270, Aberdeen Street
Hawkesbury, Ontario K6A 1K7
Canada

Telephone: 613-632-5200

Contact: Linda Lacelle

Ship via		F.O.B.		Terms		Salesperson	
PURO COLLECT		Origin		Net30 days		Claude Lessard, ext. 233	
Ship date	Order Date	Our PO #	Order by		Your PO #	GST/PST #	
27/02/07	06/02/07	5131	C. Lavoie		PO00003051		
Order Qty	B.O. Qty	Current Ship.	Item #	Item Description			
20	0	20	DKC134-0044	Floor Protector Fwd LH Part 1 N° D32811P B30658 U de M : Each Selon dessin D3281 Rev.: B Job: 40353 (x5) Job: 40952 (x15)			
20	0	20	DKC134-0045	Floor Protector Fwd RH Part 2 N° D32812P B30659 U de M : Each Selon dessin D3281 Rev.: B Job: 40355 (x9) Job: 40953 (x11)			
20	0	20	DKC134-0046	Floor Protector Aft LH Part 3 N° D32813P B30660 U de M : Each Selon dessin D3281 Rev.: B Job: 40356 (x5) Job: 40954 (x15)			
20	0	20	DKC134-0047	Floor Protector Aft RH Part 4 N° D32814P B30661 U de M : Each Selon dessin D3281 Rev.: B Job: 40955			

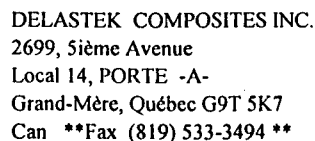
It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

Continued on next page

☐ Cust. ☐ Adm. ☒ Quality ☐ Ship.

Accepted by:


Quality department AQ-357



Invoice #	11643
Customer #	DART

Warehouse: MAIN

Bill to:

Ship to:

Contact: Linda Lacelle

It is hereby certified that all materials, process and finished items were controlled and tested in accordance with the requirements of the purchase order and applicable specifications. All such records are on file at our plant and available for review upon request.

☐ Cust. ☐ Adm. ☐ Quality ☐ Ship.


Accepted by:

Quality department AQ-357

Date: Mercredi, 2007-02-07 13:19:05
 Utilisateur: Marc Dubé

Feuille de Procédé

Client :	DART Dart Aerospace Ltd.	Nom Dessin :	FLOOR PROTECTOR AFT, LH
Numéro Job :	40955	Numéro Article :	DKC134-0047
Numéro Soumission :	2386	Numéro Dessin :	D3281
Numéro B.A. :		Projet Numéro :	DKC134
Cette fois :	2007-02-07	Révision dessin :	B
Prsht Rev. :	NC	Matériel :	F6006
Prem. fois :	--	Date Dûe :	2007-02-14
Job précédente :	40357	Qté:	20 Udm: UNITE

Type : 

Écrit par : _____
 Vérifié & Approuvé par : _____
 Commentaires : N° de pièce: D3281-4

Process Sheet Rév.: 00 Création du premier

SN: 30661

Produit additionnel

A THERMOFORMER. BV 28.02.07

Numéro Job:



Séq.: Machine ou Opération: Description :

1.0 APL0016 Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

 Commentair Qty.: 0.167 UNITE(s)/Unit Total: 3.34
 Lexan F6006 Noir N° 700 48" x 96" x .125" Th

APL0016



Lexan F6006 Noir N° 700 48" x 96" x .125" Thk.

N° de Lot: _____

Bon achat: 5913

3-5913-1

2.0 SÉCHAGE/ ANEAL SÉCHAGE / ANEALING


 Commentair Setup: 0.00Hrs/ Run: 2.0000Min Total Run : 0.6667Hrs
 SÉCHAGE DU MATÉRIEL

Sécher le matériel dans le four à 250° F pendant 6 heures.

Inscrire sur la carte de température le numéro de Job du matériel au séchage.

de cuisson: 5517

3.0 PRÉPARATION 3 PRÉPARATION DU MATÉRIEL DART


 Commentair Setup: 0.00Hrs/ Run: 3.0000Hrs Total Run : 60.0000Hrs
 TAILLAGE DU MATÉRIEL

Faire le taillage du matériel selon les dimensions suivantes:

24" x 26" x .125" Thk.

Quantité: 20 Date: 13-2-07 Sceau: _____

Quantité: _____ Date: _____ Sceau: _____



Date: Mercredi, 2007-02-07 13:19:05

Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40955

Nom Dessin: FLOOR PROTECTOR AFT, LH
Numéro Article: DKC134-0047

Numéro Job:



# Séq.:	Machine ou Opération:	Description :
---------	-----------------------	---------------


4.0	THERMOFORMAGE2	THERMOFORMAGE DES PIÈCE DART
-----	----------------	------------------------------



Commentaire Setup: 0.50Hrs/ Run: 10.0000Min Total Run : 3.3333Hrs
THERMOFORMAGE DES PIECES

Faire le thermoformage du " Floor Protector " N° D3281-4 à l'aide du moule N° D3281-4T1 sur le thermoformeur 4' x 8'.

Autocontrôle du lot de pièce thermoformées.

Quantité: 20 Date: 13-2-07 Sceau: 

Quantité: _____ Date: _____ Sceau: _____

5.0	TRIMAGE 3	TRIMAGE COMPOSITES DART
-----	-----------	-------------------------




Commentaire Setup: 0.00Hrs/ Run: 10.0000Min Total Run : 3.3333Hrs
TRIMAGE PLASTIQUE DART

Faire le trimage du " Floor Protector " N° D3281-4 à l'aide du gabarit de trimage N° D3281-4T2.

Faire l'ébavurage des pièces.

Autocontrôle du lot de pièce trimées.

Quantité: 20 Date: 13-2-07 Sceau: 


Quantité: _____ Date: _____ Sceau: _____

6.0	INSPECTION 3	INSPECTION PIÈCE DART
-----	--------------	-----------------------



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs
INSPECTION PIÈCE DART

Faire l'inspection finale des pièces selon le dessin.

Quantité: 20 Date: 23-2-07 Sceau: 

Quantité: _____ Date: _____ Sceau: _____

7.0	IDENTIFICATION4	IDENTIFICATION PIÈCES DART
-----	-----------------	----------------------------



Commentaire Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs
IDENTIFICATION PIÈCES DART

Faire l'identification des pièces à l'aide des informations suivantes:

Date: Mercredi, 2007-02-07 13:19:06
Utilisateur: Marc Dubé

Feuille de Procédé

Client: DART Dart Aerospace Ltd.
Numéro Job: 40955

Nom Dessin: FLOOR PROTECTOR AFT, LH
Numéro Article: DKC134-0047

Numéro Job:



Séq.: Machine ou Opération: Description :

N° de pièce: D3281-4

N° de Job: 40955

Date de fabrication: 23-2-07

Sceau d'inspection.

Quantité: 20

Date: 23-2-07

Sceau:



Quantité:

Date:

Sceau:

8.0

EMBALLAGE

EMBALLAGE ET ENTREPOSAGE



Commentair Setup: 0.00Hrs/ Run: 5.0000Min Total Run : 1.6667Hrs
EMBALLAGE ET ENTREPOSAGE

Emballer les pièces individuellement dans un sac en plastique et ensuite mettre dans une boîte en carton identifiée comme suit:

N° de pièce: D3281-4

Date de fabrication:

N° de job:

Quantité: 20

Date: 23/2/07

Sceau:



Quantité:

Date:

Sceau: